

FIG. 2b

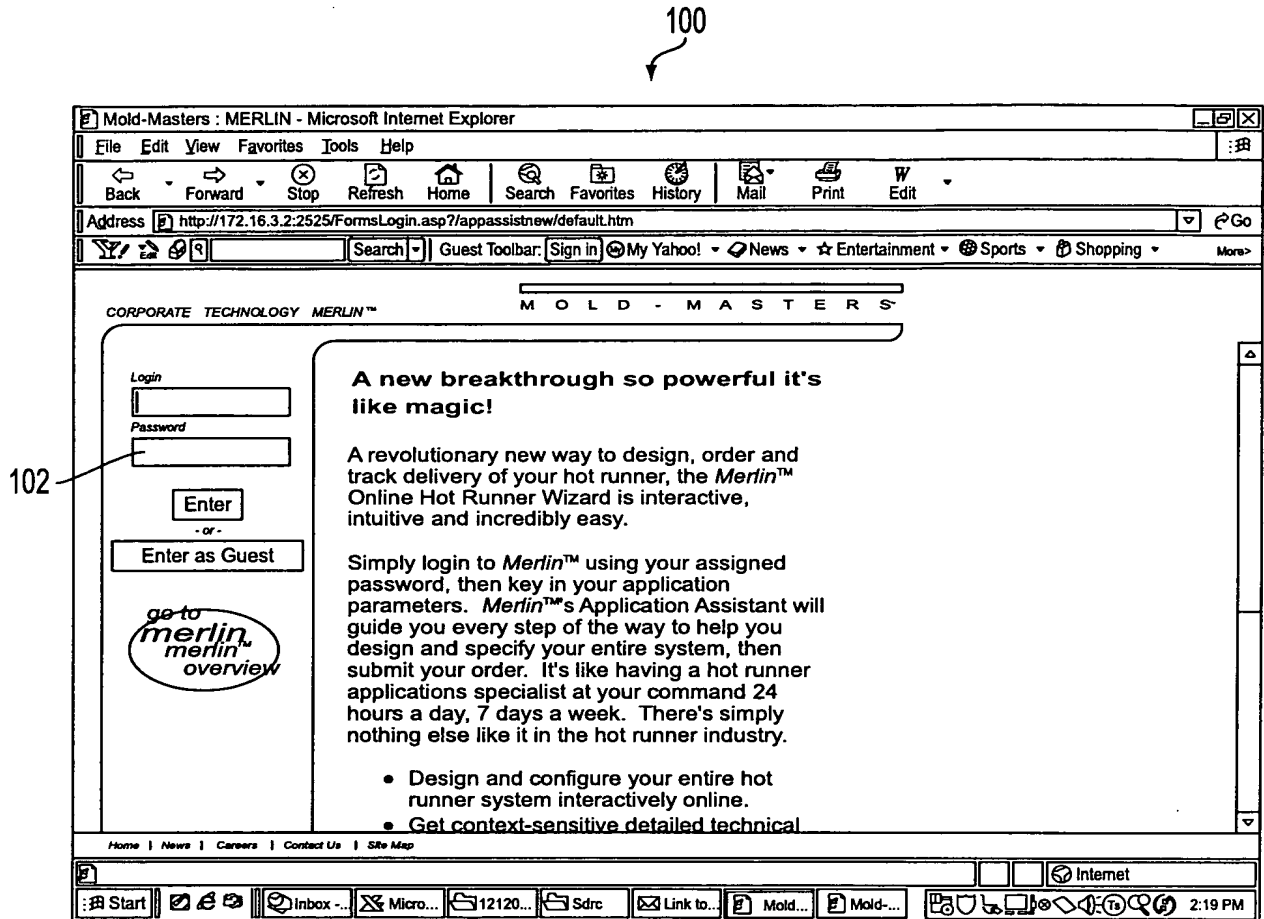


FIG. 3

110

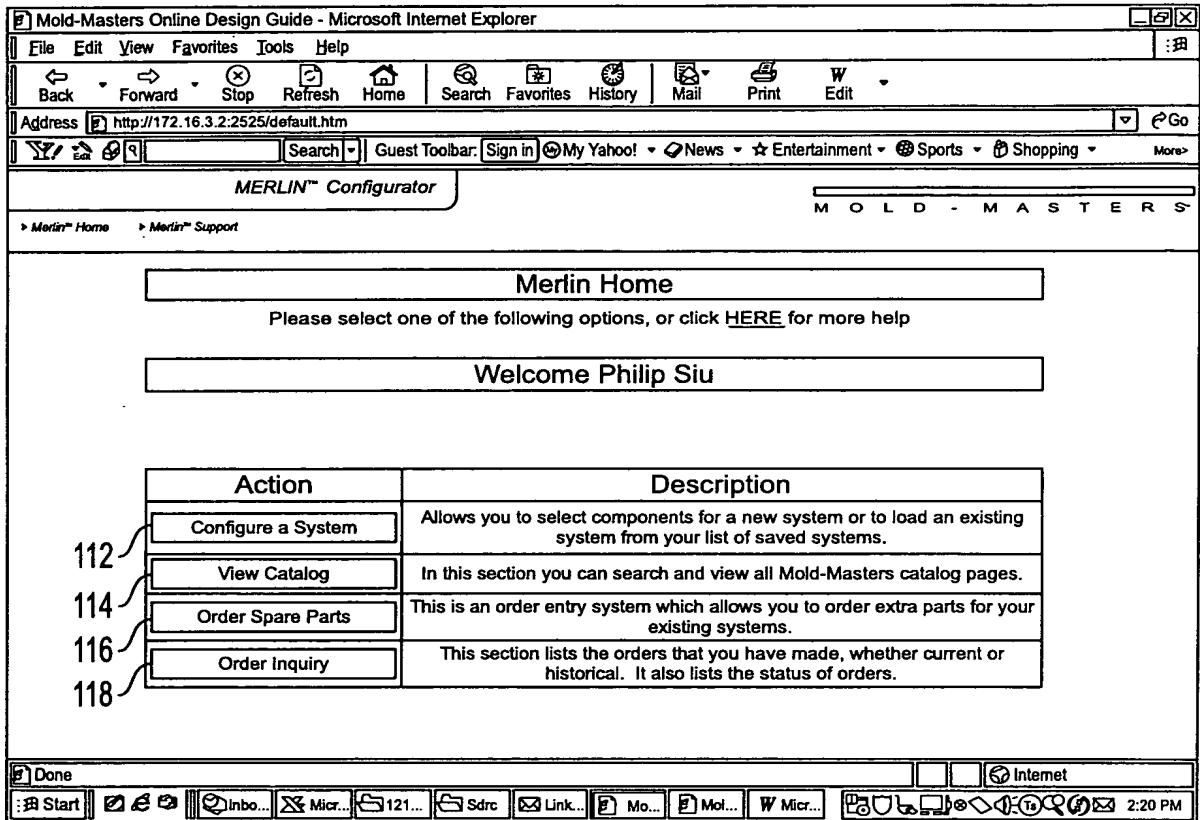


FIG. 4

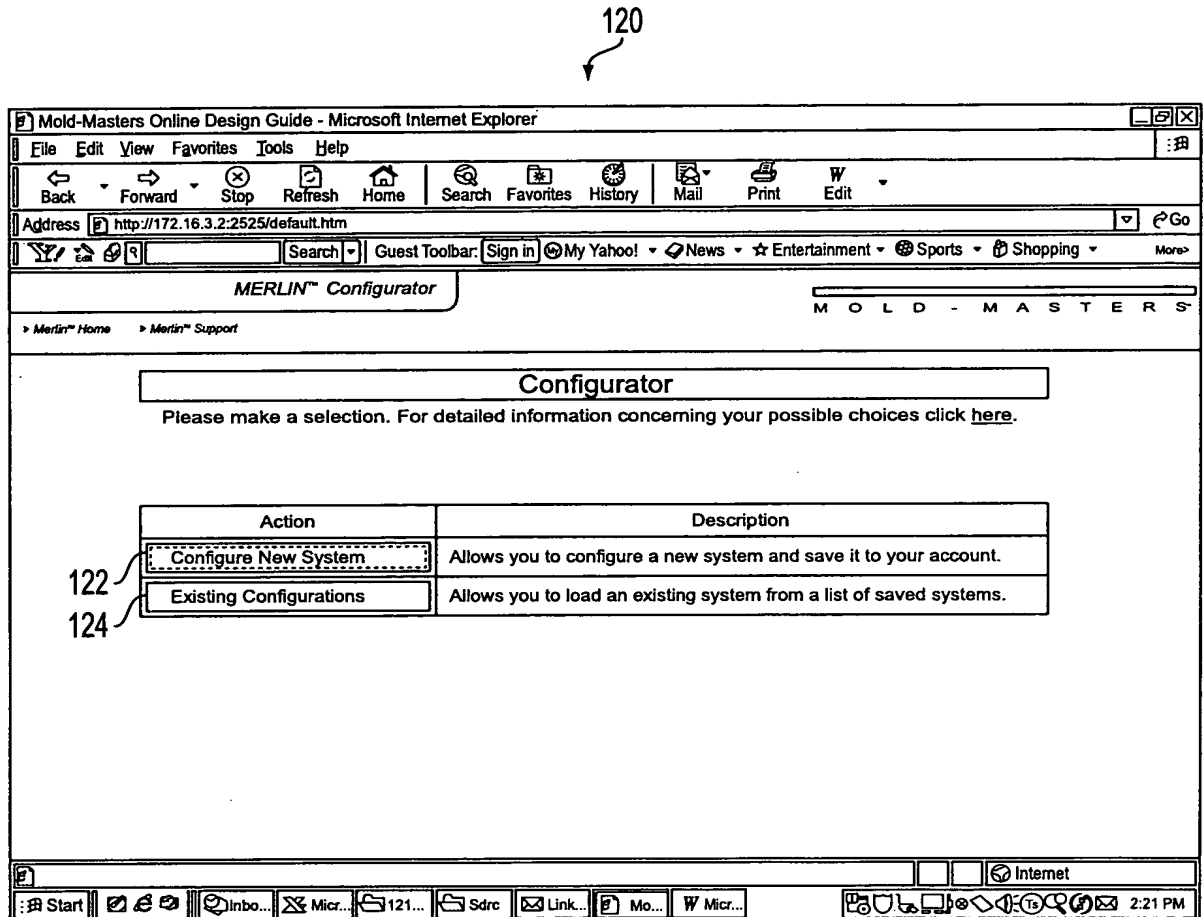


FIG. 5

130

Mold-Masters Online Design Guide - Microsoft Internet Explorer

File Edit View Favorites Tools Help

Back Forward Stop Refresh Home Search Favorites History Mail Print Edit

Address <http://172.16.3.2:2525/default.htm> Go

Search Guest Toolbar: Sign in My Yahoo! News Entertainment Sports Shopping More

MERLIN™ Configurator MOLD - MASTERS

Merlin™ Home Merlin™ Support

Shot weight/material Selection

Please choose a Shot Weight, material and the filler percentage and select the GO button.
Please click [HERE](#) for additional help.

132 134 136

Shot Weight per Nozzle	Material	Filler percentage
500 - 3500 g	Acrylonitrile Butadiene Styr.	
	Go	

Done Internet

Start Inbo... Micr... 121... Sdrc Link... Mo... W Micr... 2:21 PM

FIG. 6

140

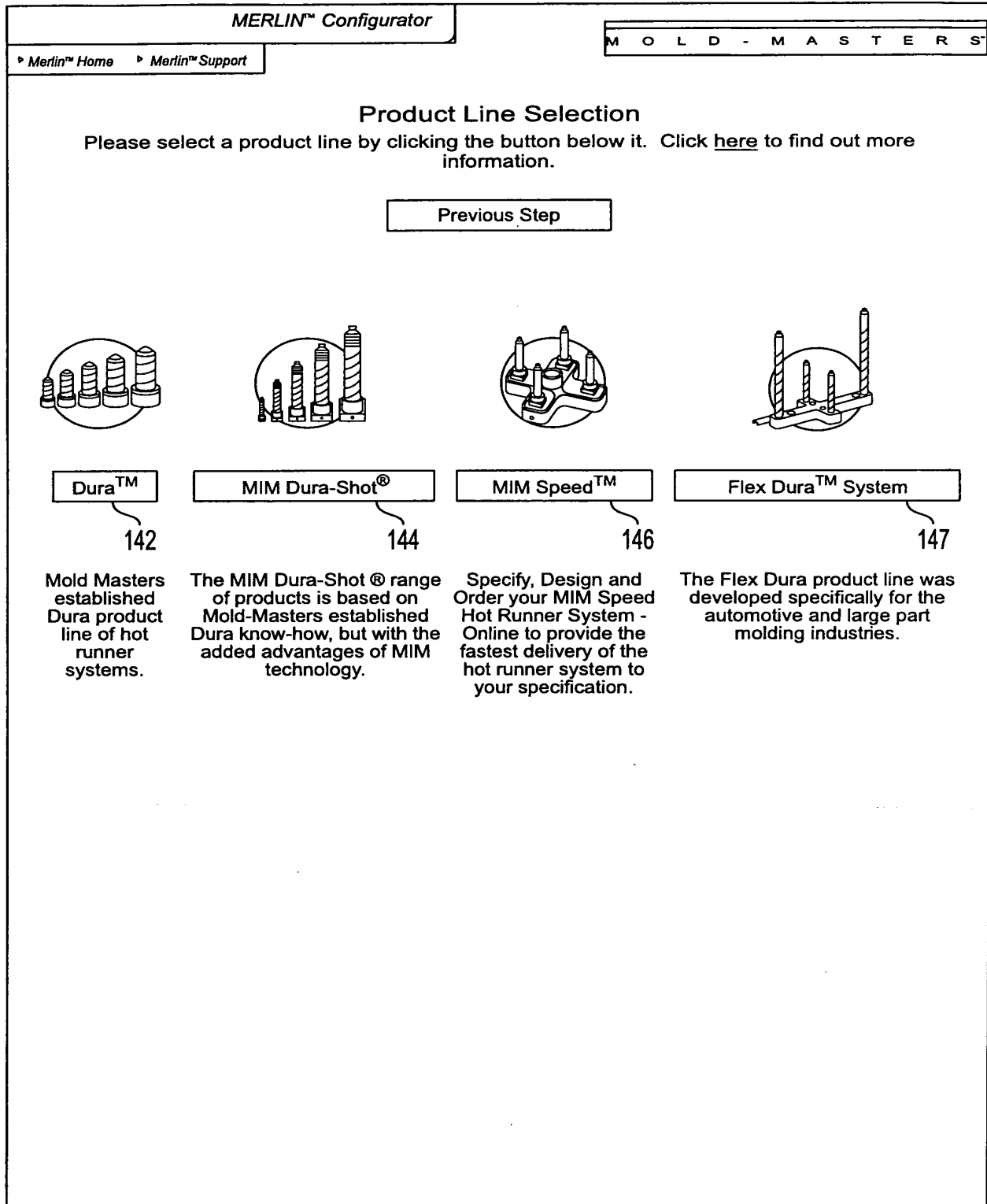


FIG. 7

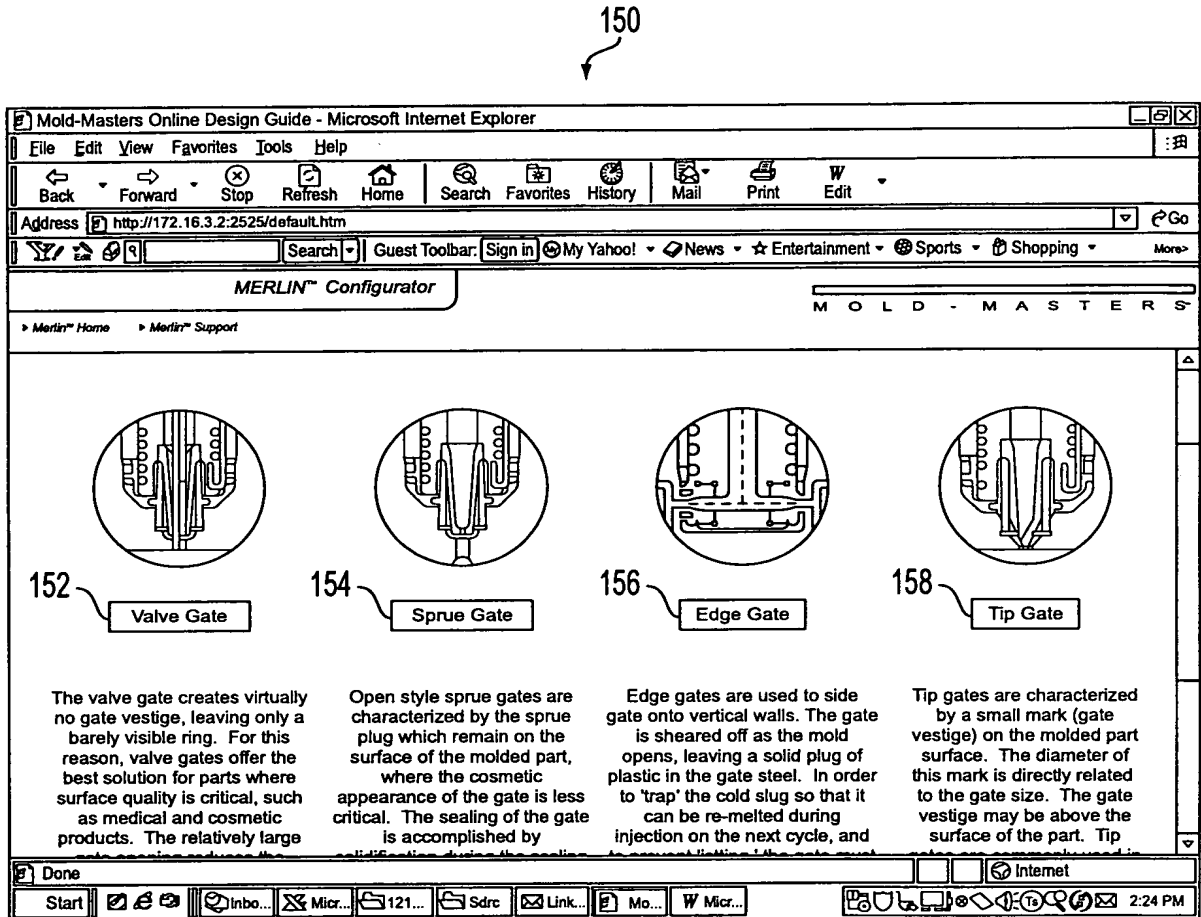


FIG. 8

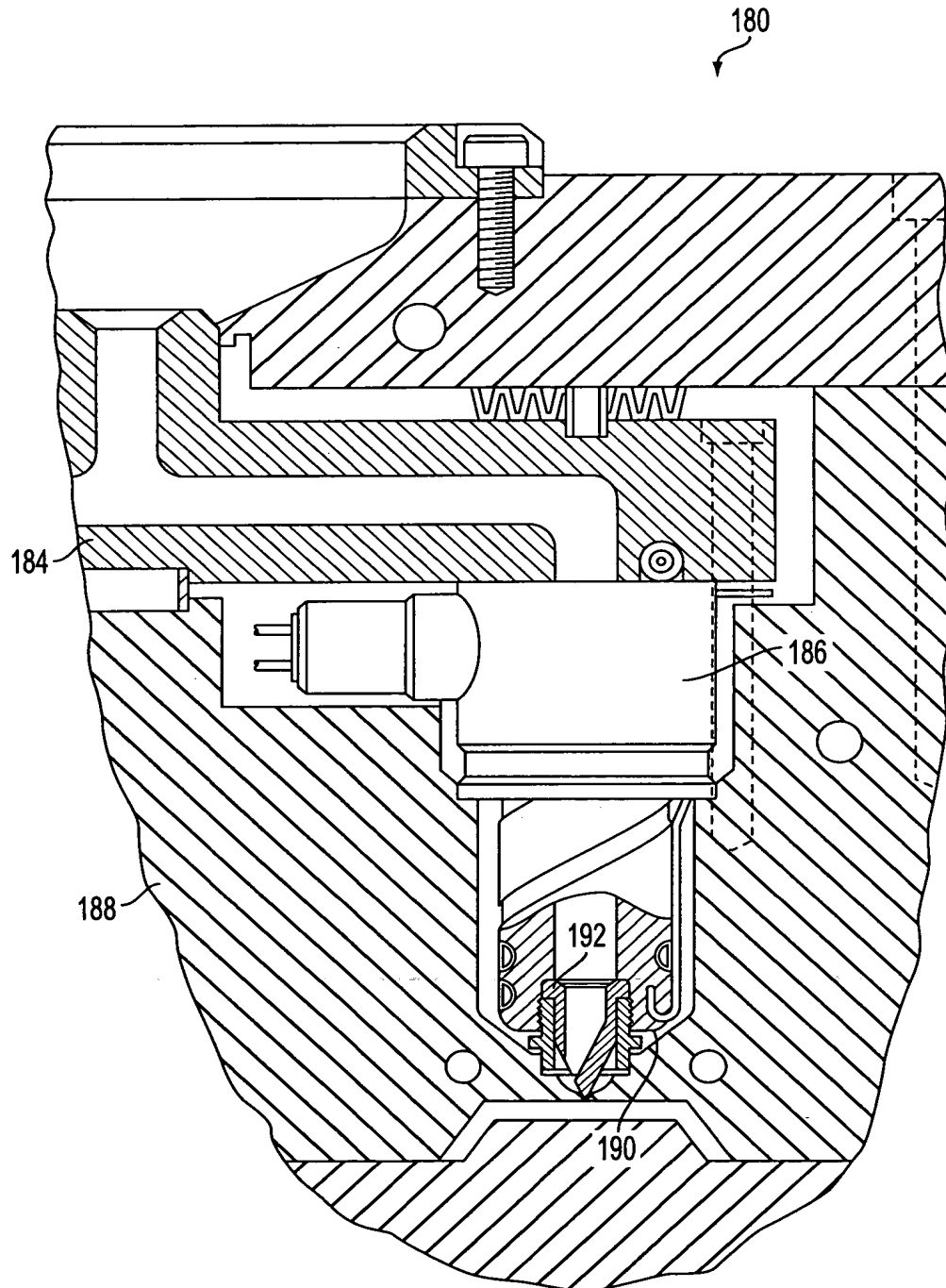


FIG. 10

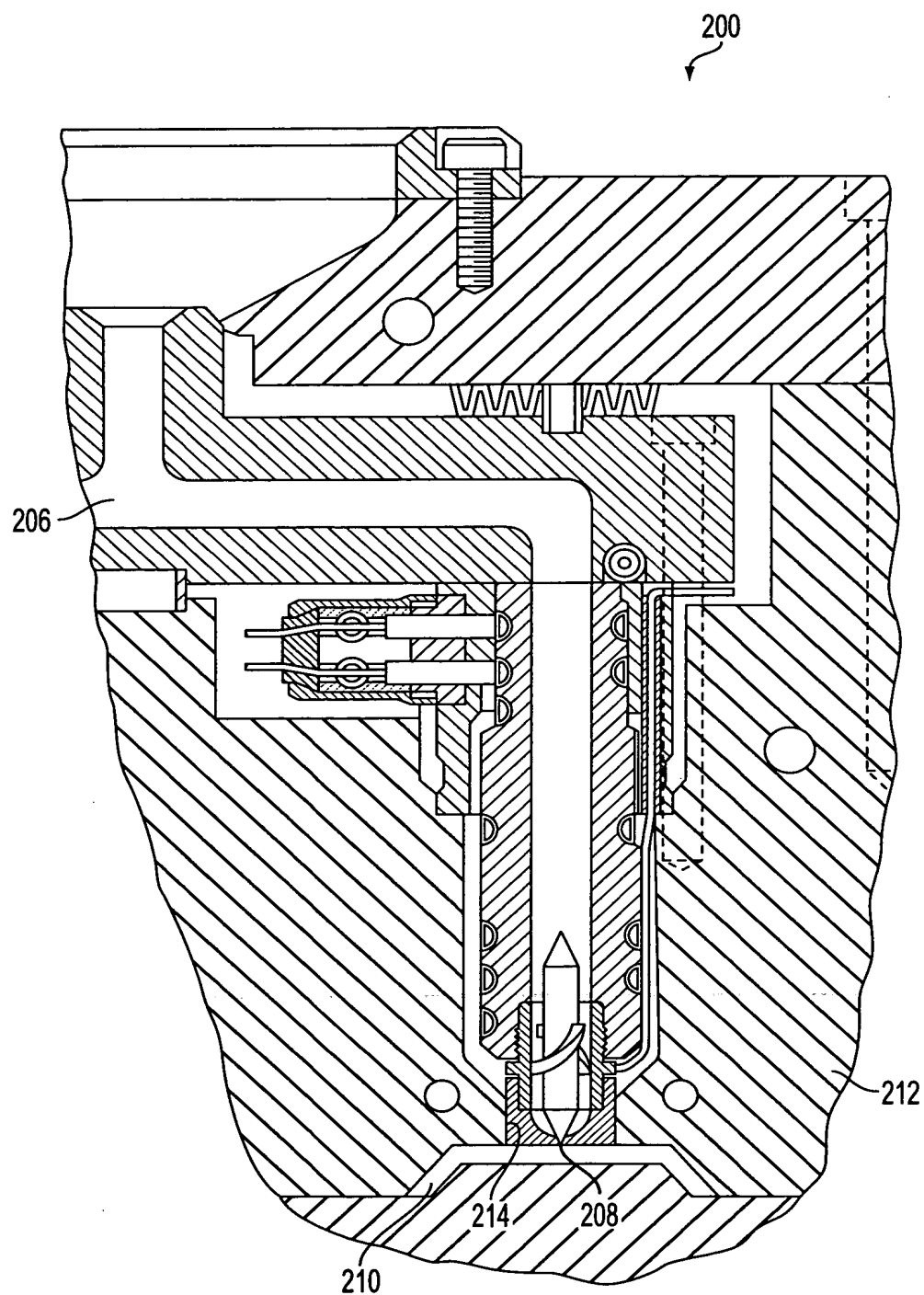


FIG. 11

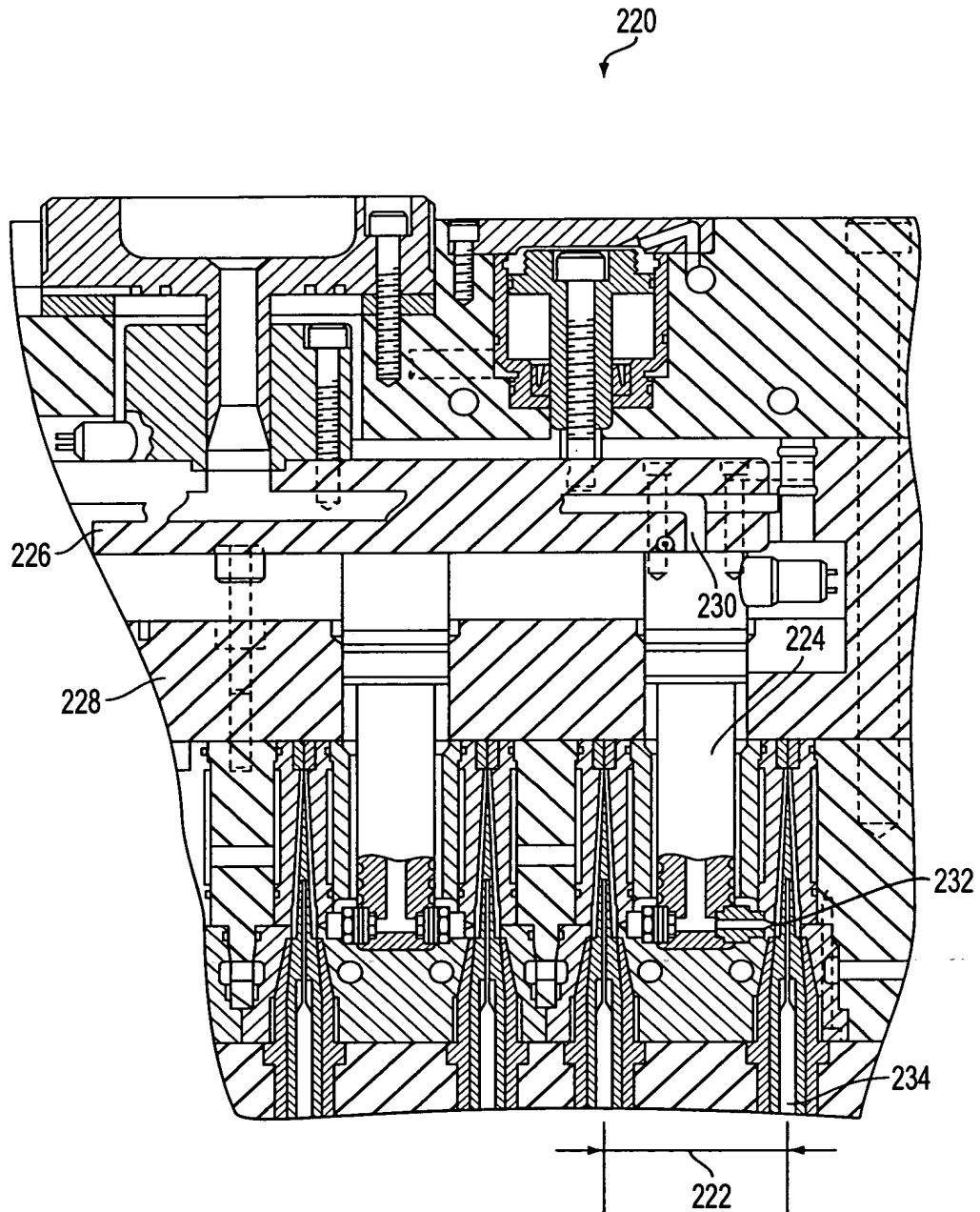


FIG. 12

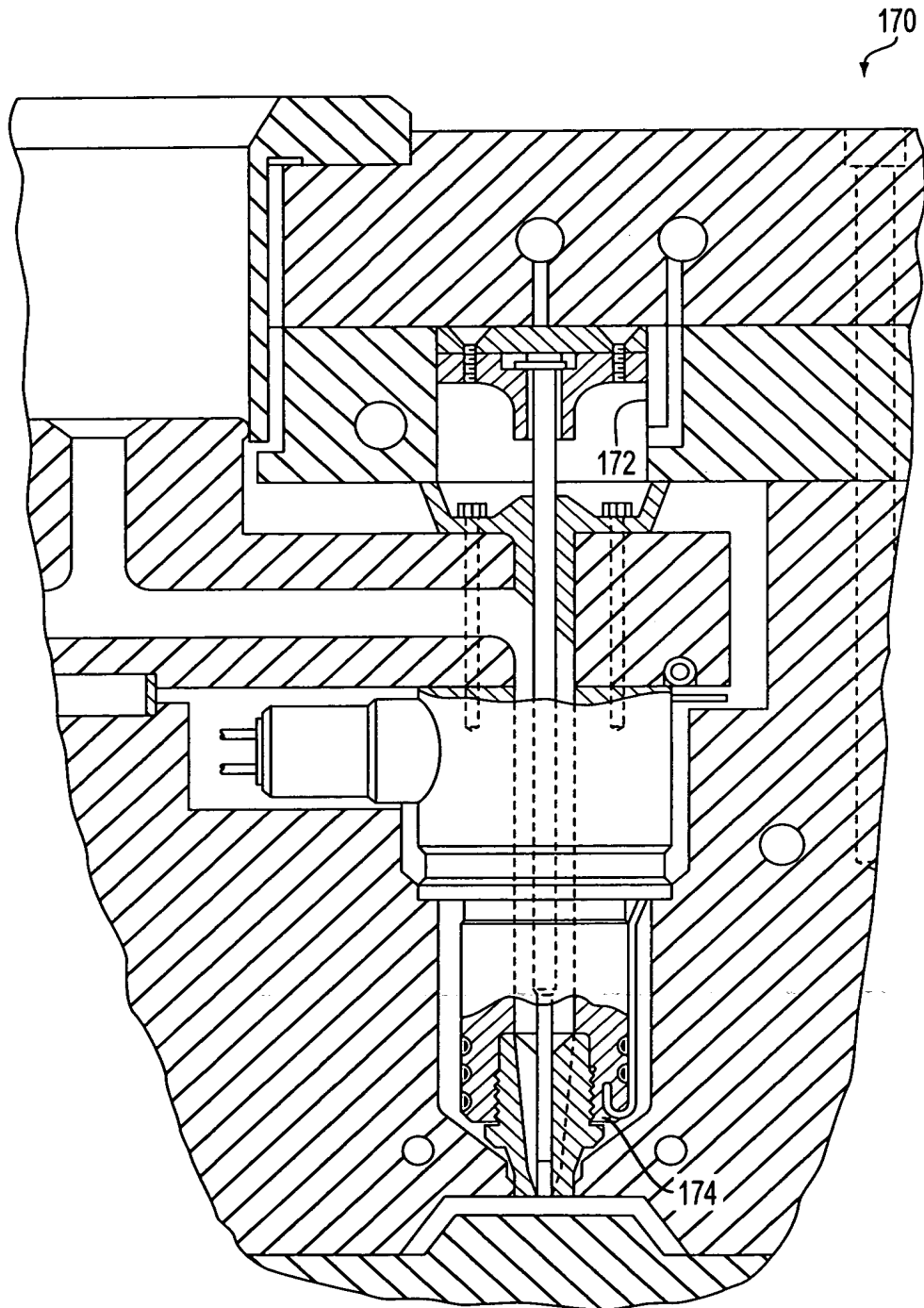


FIG. 9

240

MERLIN™ Configurator

M O L D - M A S T E R S™

Merlin™ HomeMerlin™ Support

System type/Gating method Selection

Click on the number beside the system type to continue. Click on one of the links below to find out more information about the item

Click [Here](#) for more information.

Previous Step

Match	System Type	Gating Method	Suitability	Catalog Page/s
<div>1</div>	<div>MIM Speed Dura</div> <div>Hecto-Shot</div>	<div>Bi-Metallic C-Valve</div>	<div>Recommended</div>	<div>View</div> M8.01.05

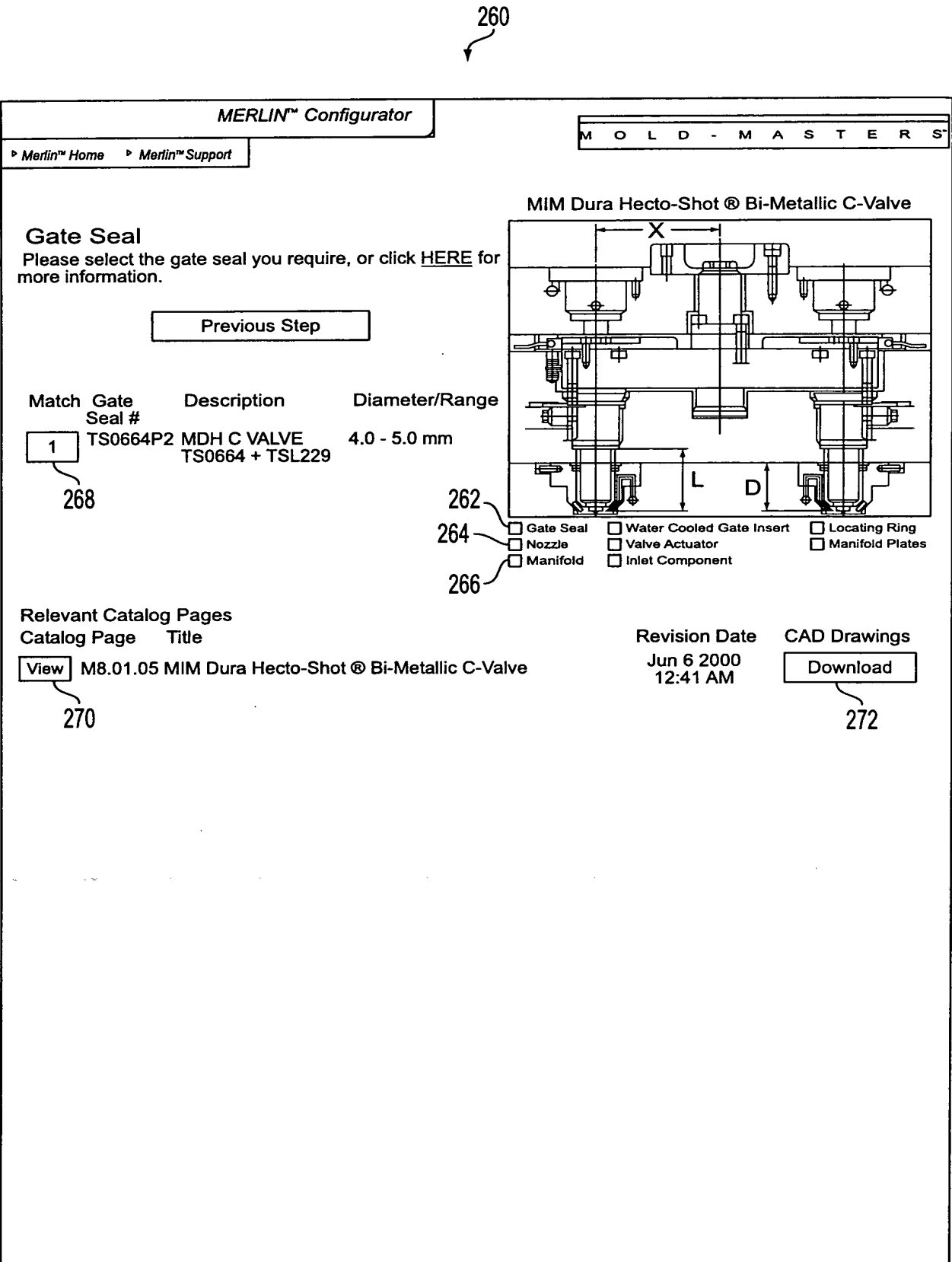
242

244

246

248

FIG. 13



280

MERLIN™ Configurator

M O L D - M A S T E R S™

Merlin™ Home

Merlin™ Support

Nozzle

Please select the nozzle you require, or click [HERE](#) for more information.

Previous Step

Match	Nozzle #	Description	L-Dim (mm)
282	1	NZMH1B1A060P Mim Dura Hecto Valve nozzle L=60	74
284	2	NZMH1B1A090P Mim Dura Hecto Valve nozzle L=90	104
286	3	NZMH1B1A120P Mim Dura Hecto Valve nozzle L=120	134
288	4	NZMH1B1A150P Mim Dura Hecto Valve nozzle L=150	164

Relevant Catalog Pages

Catalog Page	Title
290	View M8.01.05 MDH C VALVE TS0664 + TSL229
	View M8.01.05 MIM Dura Hecto-Shot ® Bi-Metallic C-Valve

MIM Dura Hecto-Shot ® Bi-Metallic C-Valve

☐ Gate Seal
☐ Nozzle
☐ Manifold

☐ Water Cooled Gate Insert
☐ Valve Actuator
☐ Inlet Component

☐ Locating Ring
☐ Manifold Plates

View

View

Revision Date

Jun 6 2000 12:41 AM

Jun 6 2000 12:41 AM

CAD Drawings

Download

Download

292

FIG. 15

300

MERLIN™ Configurator

Merlin™ HomeMerlin™ Support

M O L D - M A S T E R S™

Number Of Nozzles Selection

Please select the number of nozzles required for your system, or Click [HERE](#) for more information

Previous Step

Enter Number of Nozzles/Drops desired in System

302

1

2 Nozzles

304

2

4 Nozzles

306

View

M8.01.05 Mim Dura Hecto Valve nozzle L=120

View

M8.01.05 MDH C VALVE TS0664 + TSL229

View

M8.01.05 MIM Dura Hecto-Shot ® Bi-Metallic C-Valve

Revision Date

Jun 6 2000
12:41AM

Jun 6 2000
12:41AM

Jun 6 2000
12:41AM

CAD Drawings

Download

Download

Download

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FIG. 16

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MERLIN™ Configurator

Merlin™ HomeMerlin™ Support


M O L D - M A S T E R S™

Manifold Configuration Selection

Please choose a suitable manifold configuration from the icons shown below or click
[HERE](#) for more detailed information.

Previous Step

Standard Sub Manifolds

324

Relevant Catalog Pages

Catalog Page	Title	Revision Date	CAD Drawings
View	M8.01.05 Mim Dura Hecto Valve nozzle L=120	Jun 6 2000 12:41AM	Download
View	M8.01.05 MDH C VALVE TS0664 + TSL229	Jun 6 2000 12:41AM	Download
View	M8.01.05 MIM Dura Hecto-Shot ® Bi-Metallic C-Valve	Jun 6 2000 12:41AM	Download

326

328

FIG. 17

340

MERLIN™ Configurator

Merlin™ HomeMerlin™ Support

M O L D - M A S T E R S™

Sub Manifold Pitch Selection

Click [HERE](#) for more detailed information

Previous Step

Click the Next button to accept this dimension or enter a smaller pitch dimension for your application if required.

Off Pitch X:

Next

342

Relevant Catalog Pages

Catalog Page	Title	Revision Date	CAD Drawings
View	M8.01.05 Mim Dura Hecto Valve nozzle L=120	Jun 6 2000 12:41AM	Download
View	M8.01.05 MDH C VALVE TS0664 + TSL229	Jun 6 2000 12:41AM	Download
View	M8.01.05 MIM Dura Hecto-Shot ® Bi-Metallic C-Valve	Jun 6 2000 12:41AM	Download

344

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FIG. 18

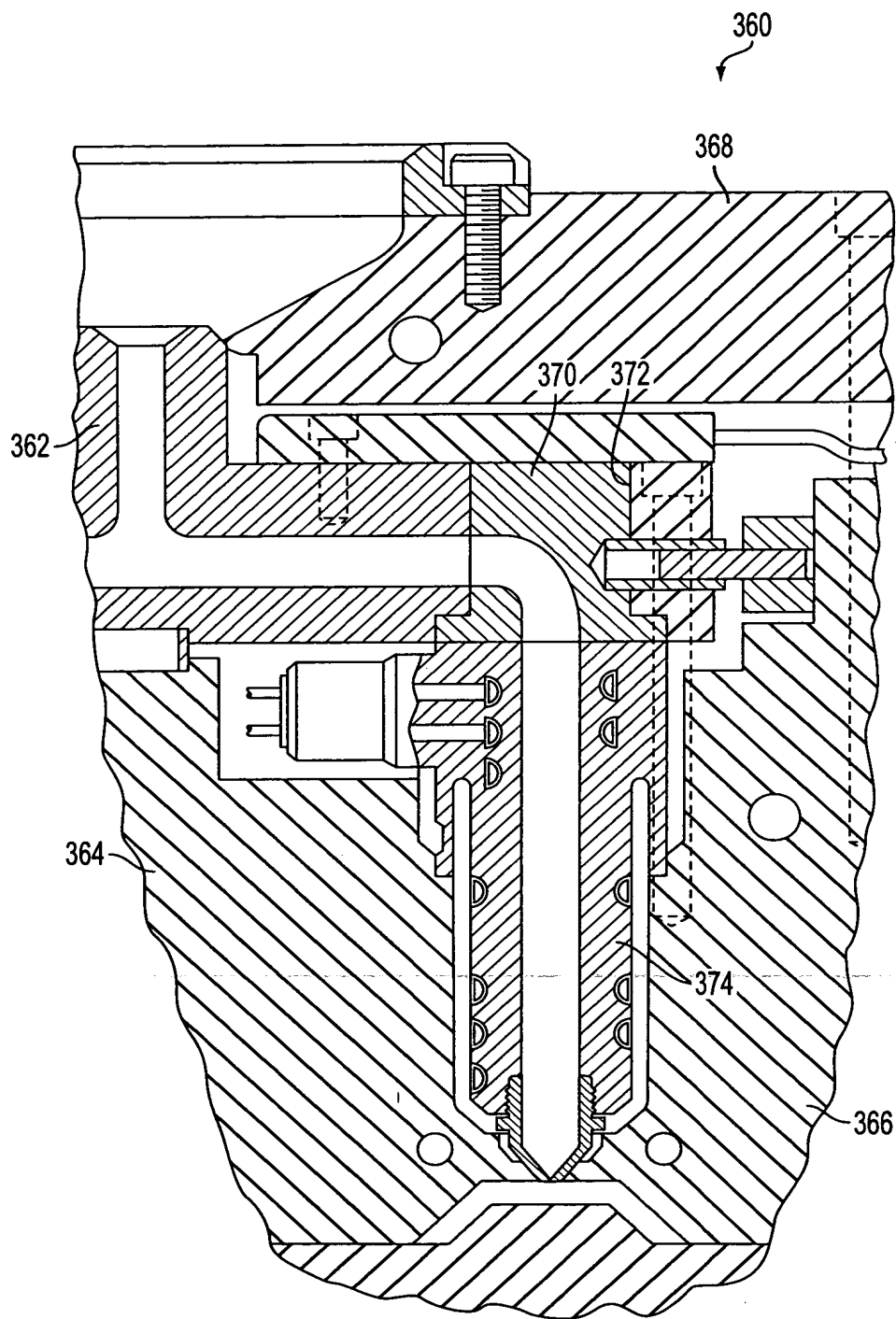


FIG. 19

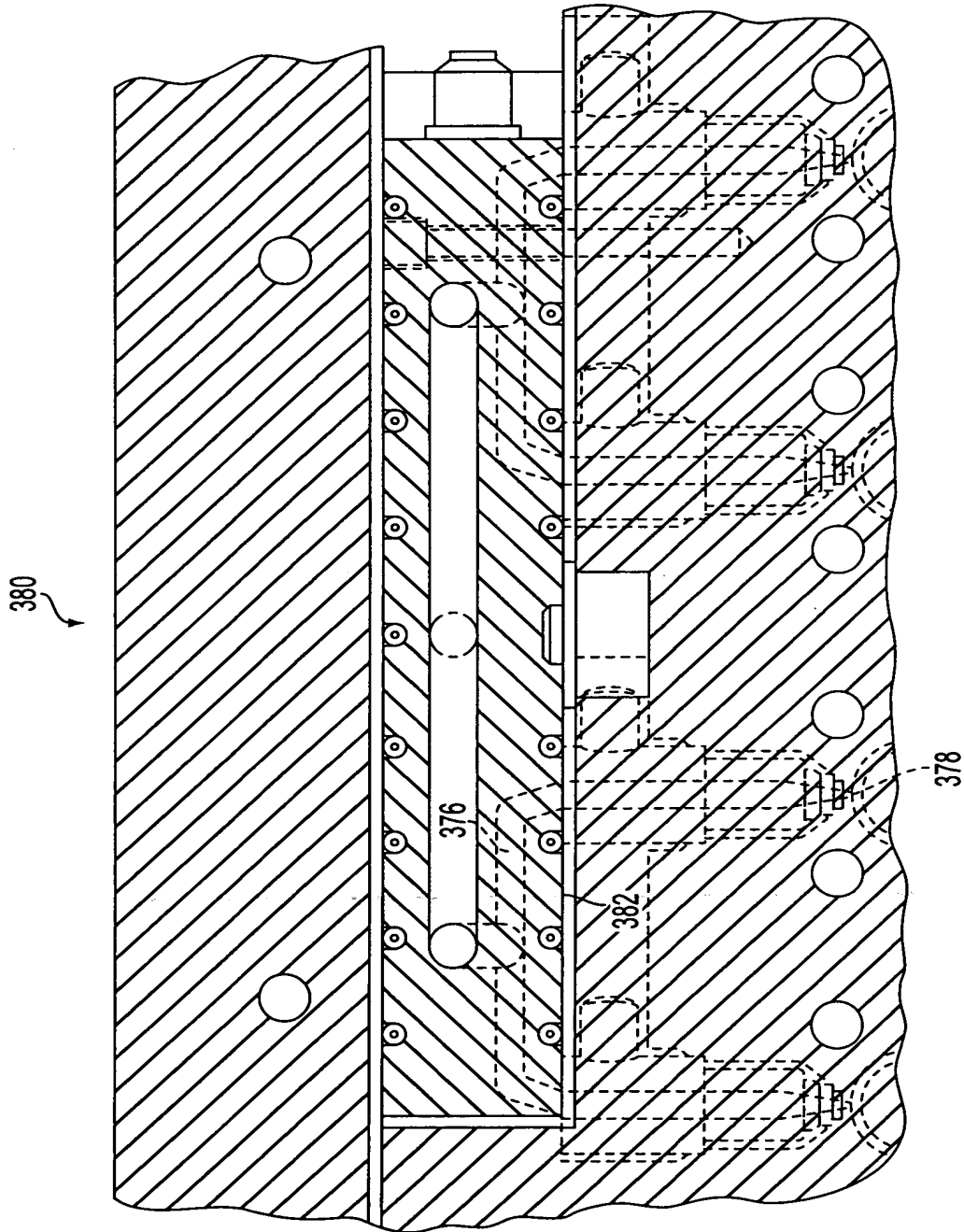


FIG. 20

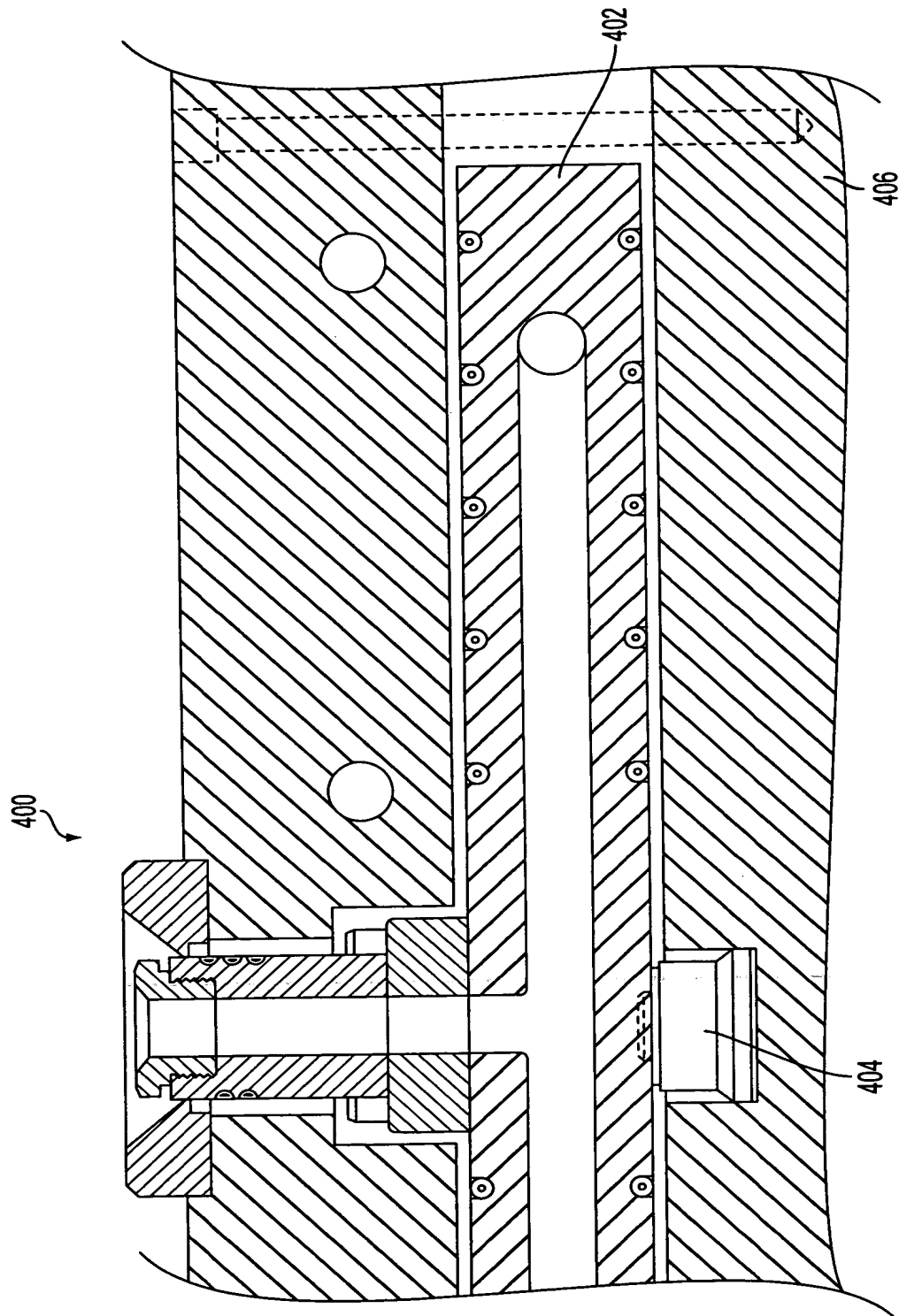


FIG. 21

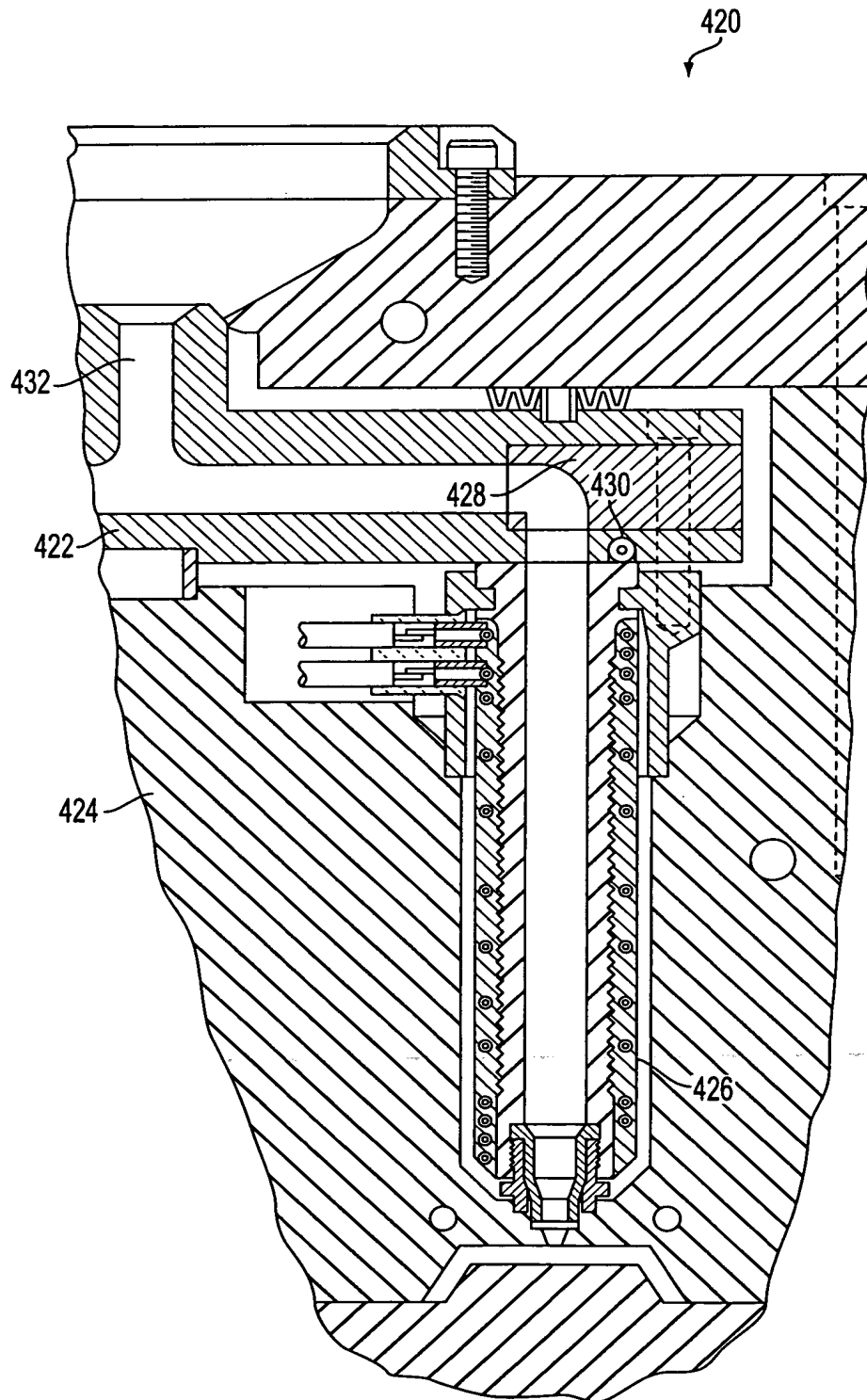


FIG. 22

440

MERLIN™ Configurator

M O L D - M A S T E R S™

[Merlin™ Home](#)
[Merlin™ Support](#)

Water Cooled Gate Insert (Optional)

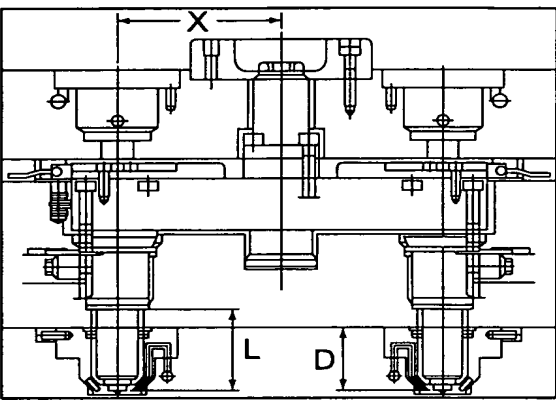
Please select the gate insert you require, or click [HERE](#) for more information.

Previous Step

Match Gate	Description	D- Dimension
Insert #		
Water Cooled Gate Inserts are not available for this application.		

NEXT

MIM Dura Hecto-Shot® Bi-Metallic C-Valve



☐ Gate Seal

☐ Water Cooled Gate Insert

☐ Locating Ring

☐ Nozzle

☐ Valve Actuator

☐ Manifold Plates

☐ Manifold

☐ Inlet Component

Relevant Catalog Pages

Catalog Page	Title
View	M8.02.02 2-Inline Sub Manifold
View	M8.01.05 Mim Dura Hecto-Valve nozzle L=120
View	M8.01.05 MDH C VALVE TS0664 + TSL229
View	M8.01.05 MIM Dura Hecto-Shot® Bi-Metallic C-Valve

Revision Date	CAD Drawings
Jun	Download
Jun 6 2000 12:41AM	Download
Jun 6 2000 12:41AM	Download
Jun 6 2000 12:41AM	Download

FIG. 23

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MERLIN™ Configurator

M O L D - M A S T E R S™

[Merlin™ Home](#) [Merlin™ Support](#)

Valve Actuator

Please select the valve actuator you require, or click [HERE](#) for more information.

Previous Step

Match	Valve Actuator #	Description	Valve Pin Max. Length	Valve Pin Diameter	Valve Pin Stroke
1	HY6600D	Hydraulic/Pneumatic Cylinder Assembly	355.0 mm	7.940 mm	20.0 mm

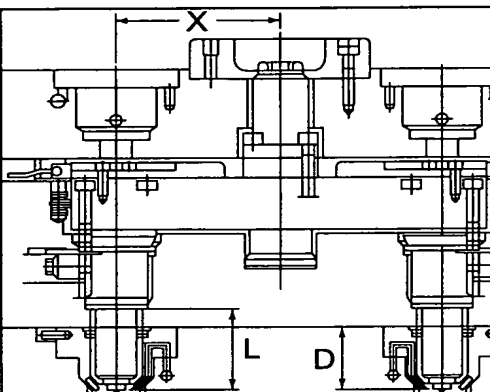
464

Relevant Catalog Pages

Catalog Page	Title
View	M8.02.02 2-Inline Sub Manifold
View	M8.01.05 Mim Dura Hecto Valve nozzle L=120
View	M8.01.05 MDH C VALVE TS0664 + TSL229
View	M8.01.05 MIM Dura Hecto-Shot ® Bi-Metallic C-Valve

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MIM Dura Hecto-Shot ® Bi-Metallic C-V



☐ Gate Seal
☐ Nozzle
☐ Manifold

☐ Water Cooled Gate Insert
☐ Valve Actuator
☐ Inlet Component

☐ Locating
☐ Manifold

462

Revision	Date	CAD Drawings
	Jun	Download
Jun 6 2000	12:41AM	Download
Jun 6 2000	12:41AM	Download
Jun 6 2000	12:41AM	Download

468

FIG. 24

480

MERLIN™ Configurator

Merlin™ Home

Merlin™ Support

M O L D - M A S T E R S™

Inlet Component

Please select the Inlet Component you require, or click [HERE](#) for more information.

Previous Step

Matches

Description

1

Manifold center heater

484

MIM Dura Hecto-Shot® Bi-Metallic C-Valve

☐ Gate Seal

☐ Nozzle

☐ Manifold

☐ Water Cooled Gate Insert

☐ Valve Actuator

☐ Inlet Component

☐ Locating Ring

☐ Manifold Plates

482

Relevant Catalog Pages

Catalog Page	Title
View	12.01.12 Hydraulic/Pneumatic Cylinder Assembly
View	M8.02.02 2-Inline Sub Manifold
View	M8.01.05 Mim Dura Hecto Valve nozzle L=120
View	M8.01.05 MDH C VALVE TS0664 + TSL229
View	M8.01.05 MIM Dura Hecto-Shot® Bi-Metallic C-Valve

486

Revision Date

CAD Drawings

98-Oct-22	Download
Jun	Download
Jun 6 2000 12:41 AM	Download
Jun 6 2000 12:41 AM	Download
Jun 6 2000 12:41 AM	Download

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FIG. 25

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MERLIN™ Configurator

M O L D - M A S T E R S™

Merlin™ Home

Merlin™ Support

Inlet Component Manifold center heater
Please select the Inlet Component you require, or click [HERE](#) for more information.

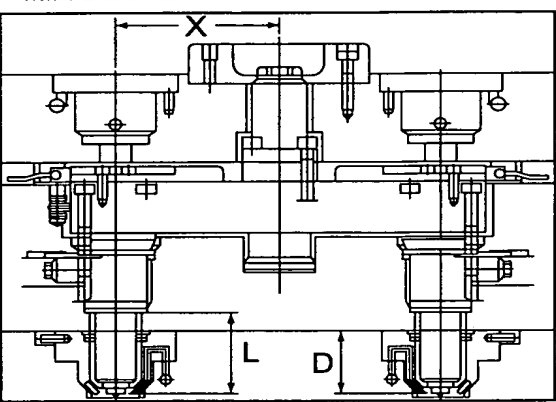
Previous Step

Matches	Inlet Component #	Machine Nozzle Radius
1	BP58.500P	0.5 inch
2	BP58.750P	0.75 inch

Relevant Catalog Pages

Catalog Page	Title	Revision Date	CAD Drawings
View	12.01.12 Hydraulic/Pneumatic Cylinder Assembly	98-Oct-22	Download
View	M8.02.02 2-Inline Sub Manifold	Jun	Download
View	M8.01.05 Mim Dura Hecto Valve nozzle L=120	Jun 6 2000 12:41 AM	Download
View	M8.01.05 MDH C VALVE TS0664 + TSL229	Jun 6 2000 12:41 AM	Download
View	M8.01.05 MIM Dura Hecto-Shot @ Bi-Metallic C-Valve	Jun 6 2000 12:41 AM	Download

MIM Dura Hecto-Shot @ Bi-Metallic C-Valve



☐ Gate Seal

☐ Water Cooled Gate Insert

☐ Locating Ring

☐ Nozzle

☐ Valve Actuator

☐ Manifold Plates

☐ Manifold

☐ Inlet Component

FIG. 26

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MERLIN™ Configurator

M O L D - M A S T E R S

Merlin™ Home

Merlin™ Support

Location Ring

Please select the locating ring you require, or click [HERE](#) for more information.

Previous Step

Matches	Locating Ring #	Description	Diameter (mm)
1	LR0070	Loc. ring for machine nozzle pad	101.34
2	LR0071	Loc. ring for machine nozzle pad	109.75
3	LR0081	Locating Ring for Valve system with BP58, inch	101.36
4	LR0082	Locating Ring for Valve system with BP58, metric	109.77
5	LR0086	Locating Ring for Sprue system with BP58, inch	101.36
6	LR0087	Locating Ring for Sprue system with BP58, metric	109.77

Relevant Catalog Pages

Catalog Page	Title	Revision Date	CAD Drawings
View	10.01.11 Manifold center heater	98-Oct-22	Download
View	12.01.12 Hydraulic/Pneumatic Cylinder Assembly	98-Oct-22	Download
View	M8.02.02 2-Inline Sub Manifold	Jun	Download
View	M8.01.05 Mim Dura Hecto Valve nozzle L=120	Jun 6 2000 12:41 AM	Download
View	M8.01.05 MDH C VALVE TS0664 + TSL229	Jun 6 2000 12:41 AM	Download
View	M8.01.05 MIM Dura Hecto-Shot ® Bi-Metallic C-Valve	Jun 6 2000 12:41 AM	Download

MIM Dura Hecto-Shot ® Bi-Metallic C-Valve

522

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FIG. 27

540

MERLIN™ Configurator

M O L D - M A S T E R S™

Merlin™ Home

Merlin™ Support

Molding Elevation

If you wish to include a Molding Elevation, please enter it below and choose the Unit of Measure.

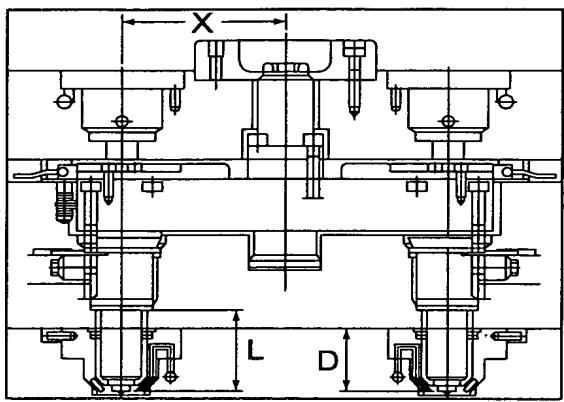
Click [HERE](#) for more information.

Previous Step

There is no Molding Elevation range available for this application. Click Next to continue or try another application.

Next

MIM Dura Hecto-Shot® Bi-Metallic C-Valve



☐ Gate Seal

☐ Water Cooled Gate Insert

☐ Locating Ring

☐ Nozzle

☐ Valve Actuator

☐ Manifold Plates

☐ Manifold

☐ Inlet Component

Relevant Catalog Pages

Catalog Page	Title	Revision Date	CAD Drawings
View	M9.01.08 Locating Ring for Valve system with BP58, inch	Jun 6 2000 12:41 AM	Download
View	10.01.11 Manifold center heater	98-Oct-22	Download
View	12.01.12 Hydraulic/Pneumatic Cylinder Assembly	98-Oct-22	Download
View	M8.02.02 2-Inline Sub Manifold	Jun	Download
View	M8.01.05 Mim Dura Hecto Valve nozzle L=120	Jun 6 2000 12:41 AM	Download
View	M8.01.05 MDH C VALVE TS0664 + TSL229	Jun 6 2000 12:41 AM	Download
View	M8.01.05 MIM Dura Hecto-Shot® Bi-Metallic C-Valve	Jun 6 2000 12:41 AM	Download

FIG. 28

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MERLIN™ Configurator		M O L D - M A S T E R S™	
Merlin™ Home Merlin™ Support			
<h3>Application Information Form</h3> <p>Please fill in the relevant information and check for correctness.</p>			
<div style="border: 1px solid black; display: inline-block; padding: 5px 20px;">Previous Step</div>			
Action To Be Taken. For more information click HERE			
Company Name:		Contact Name <input style="width: 150px;" type="text"/>	
Mold Maker <input style="width: 150px;" type="text"/>	Molder <input style="width: 150px;" type="text"/>	End User <input style="width: 150px;" type="text"/>	
Customer Ref. # <input style="width: 150px;" type="text"/>		Requested Delivery Date <input style="width: 100px;" type="text"/> (in MM/DD/YYYY format)	
Plastic Part # <input style="width: 150px;" type="text"/>	Plastic Part Name <input style="width: 200px;" type="text"/>	Industry Segment <input style="width: 250px;" type="text"/>	
Additional information			
Material	Part	Mold	Other
<u>Material type :</u>	<u>Shot Weight :</u>	<u># of Cavities</u>	<u>Gate Cosmetics</u>
Acrylonitrile Butadiene Styr.	500 - 3500 g	<input style="width: 150px;" type="text"/>	<input style="width: 150px;" type="text"/>
<u>Grade</u>	<u>Est. Injection Time (sec.)</u>	<u>Sub-runners</u>	<u>Gate Cooling</u>
<input style="width: 150px;" type="text"/>	<input style="width: 100px;" type="text"/>	<input style="width: 50px;" type="text"/> <input style="width: 50px;" type="text"/>	<input style="width: 150px;" type="text"/>
<u>Supplier</u>	<u>Wall Thickness</u>	<u>Gate</u>	<u>Dim. Stability</u>
<input style="width: 200px;" type="text"/>	<input style="width: 100px;" type="text"/> <input style="width: 50px;" type="text"/>	<input style="width: 100px;" type="text"/> mm <input style="width: 50px;" type="text"/>	<input style="width: 150px;" type="text"/>
<u>Process Temp</u>	<u>Flow Length</u>	<u>Land</u>	<u>Supp. Screws</u>
<input style="width: 50px;" type="text"/> C <input style="width: 50px;" type="text"/>	<input style="width: 100px;" type="text"/> mm <input style="width: 50px;" type="text"/>	<input style="width: 100px;" type="text"/> mm <input style="width: 50px;" type="text"/>	<input style="width: 150px;" type="text"/>

FIG. 29

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MERLIN™ Configurator

M O L D - M A S T E R S™

Merlin™ Home

Merlin™ Support

Summary Information Form

Please fill in the relevant information and check for correctness.

Previous Step

View Printable Version

Action To Be Taken. For more information click [HERE](#)

Step 1

Save

582

Step 2

Quote

584

Step 3

Review

586

Step 4

Order

588

Lead Time: No Lead Time Available.

Quote #: 0040003107

Not Reviewed.

Order #:

Generate Drawings

Price: \$6,681.00 USD

PO #

N/A

Company Name: 590

Contact Name:

Mold Maker:

Molder:

End User:

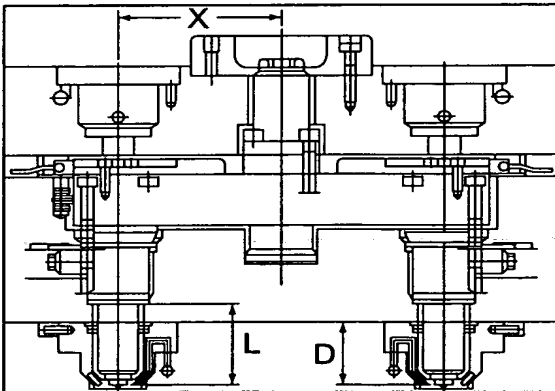
Customer Ref. # :

Requested Delivery Date:

Plastic Part # :

Plastic Part Name:

Industry Segment:



Part Number	Description	Options
TS0664P2	MDH C VALVE TS0664 + TSL229	N/A
NZMH1B1A120P	Mim Dura Hecto Valve nozzle L=120	N/A
MNMDH21200BL4VP	2-Inline Sub Manifold	N/A
HY6600D	Hydraulic/Pneumatic Cylinder Assembly	N/A
BP58.750P	Manifold center heater	N/A
LR0081	Locating Ring for Valve system with BP58, inch	N/A

Additional Information

Material	Part	Mold	Other
Material type : Acrylonitrile Butadiene Styr.	Shot Weight : 500 - 3500g	# of Cavities :	Gate Cosmetics :
Grade:	Est. Injection Time (sec.):	Sub-runners:	Gate Cooling:
Supplier:	Wall Thickness:	Gate:	Dim. Stability:

FIG. 30

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Generated Drawings

Choose any of the file options below to download or view online

Type	Drawings	Options
TIF	<u>GT_sys_valve_config_HY6600_0077.tif</u> (1449539 Bytes)	<div style="border: 1px solid black; padding: 2px; display: inline-block;">Download</div> <div style="border: 1px solid black; padding: 2px; display: inline-block; margin-top: 5px;">View</div>
TIF	<u>GT_sys_valve_config_SYSTEM_ASSEMBLY.tif</u> (1170968 Bytes)	<div style="border: 1px solid black; padding: 2px; display: inline-block;">Download</div> <div style="border: 1px solid black; padding: 2px; display: inline-block; margin-top: 5px;">View</div>
DXF	<u>GT_sys_valve_config_HY6600_0077.dxf</u> (1095118 Bytes)	<div style="border: 1px solid black; padding: 2px; display: inline-block;">Download</div> <div style="border: 1px solid black; padding: 2px; display: inline-block; margin-top: 5px;">View</div>
DXF	<u>GT_sys_valve_config_SYSTEM_ASSEMBLY.dxf</u> (1786603 Bytes)	<div style="border: 1px solid black; padding: 2px; display: inline-block;">Download</div> <div style="border: 1px solid black; padding: 2px; display: inline-block; margin-top: 5px;">View</div>
IGS	<u>GT_sys_valve_config_HY6600_0077.igs</u> (2487962 Bytes)	<div style="border: 1px solid black; padding: 2px; display: inline-block;">Download</div> <div style="border: 1px solid black; padding: 2px; display: inline-block; margin-top: 5px;">View</div>
IGS	<u>GT_sys_valve_config_SYSTEM_ASSEMBLY.igs</u> (2302724 Bytes)	<div style="border: 1px solid black; padding: 2px; display: inline-block;">Download</div> <div style="border: 1px solid black; padding: 2px; display: inline-block; margin-top: 5px;">View</div>
WRL	<u>GeneralAssembly.wrl</u> (2461551 Bytes)	<div style="border: 1px solid black; padding: 2px; display: inline-block;">Download</div> <div style="border: 1px solid black; padding: 2px; display: inline-block; margin-top: 5px;">View</div>

FIG. 31

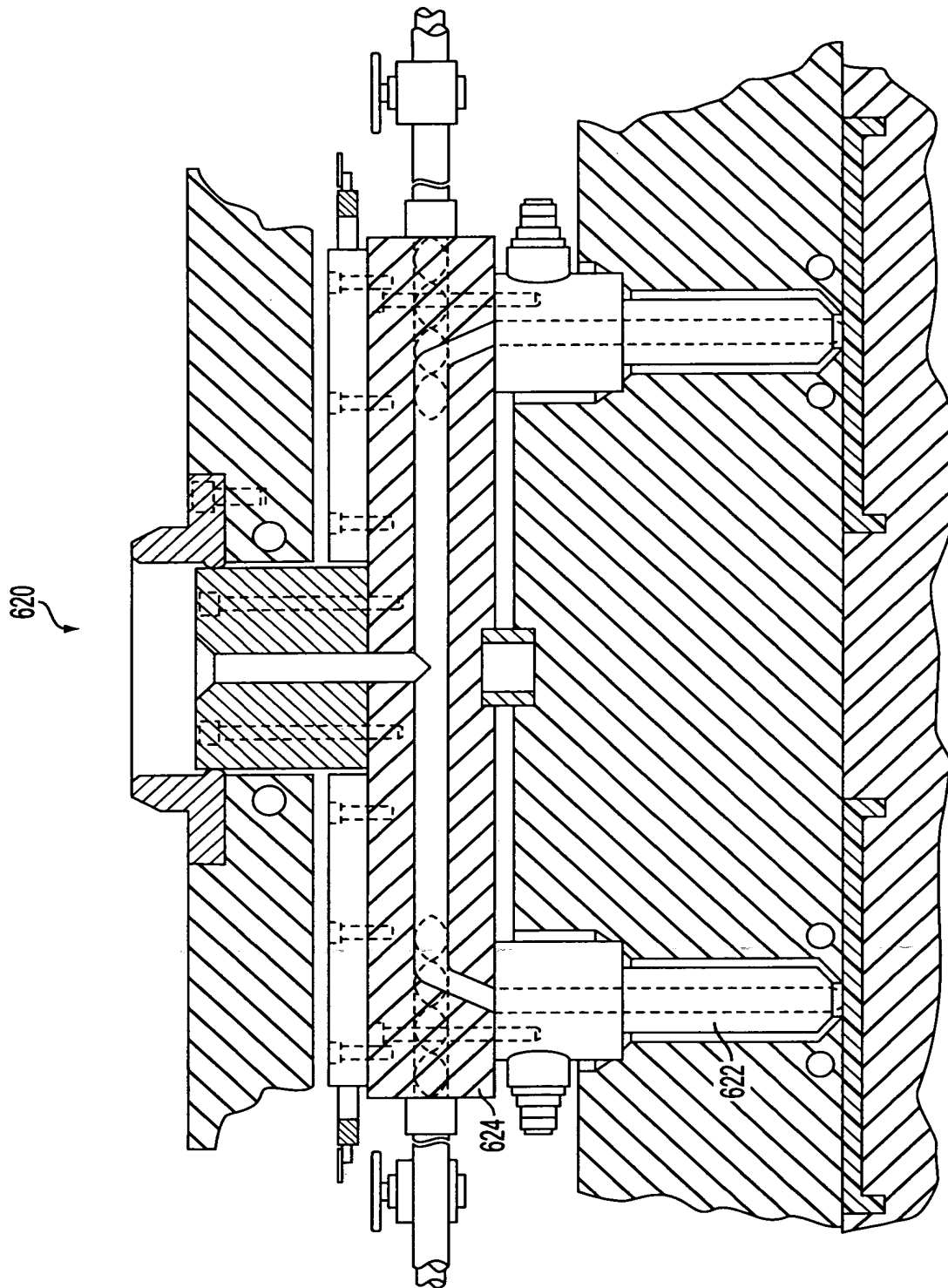


FIG. 32

640

here.' Below this, there is a table with two columns: 'Action' and 'Description'. The table lists two actions: 'Configure New System' and 'Existing Configurations'. The 'Existing Configurations' action is highlighted with a box and a callout line pointing to the number 124."/>

Action	Description
Configure New System	Allows you to configure a new system and save it to your account.
Existing Configurations	Allows you to load an existing system from a list of saved systems.

FIG. 33

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MERLIN™ Configurator

► Merlin™ Home ► Merlin™ Support

M O L D - M A S T E R S

Existing Configurations

Please Make a selection. For detailed information concerning your possible choices click [HERE](#)

Action			Configuration Name	Quote #	Order #	Date/Time Status
Load	Copy	Delete	Previous Config	0040003107		6/12/00 2:39:47 PM
Load	Copy	Delete	SAP Test	0040003098		6/9/00 11:31:20 AM
Load	Copy	Delete	2 drop hect 190 pitch	0040003093		6/8/00 1:53:36 PM

FIG. 34

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MERLIN™ Configurator

M O L D - M A S T E R S™

Merlin™ Home

Merlin™ Support

Summary Information Form

Please fill in the relevant information and check for correctness.

Previous Step

View Printable Version

Action To Be Taken. For more information click [HERE](#)

Step 1

Save

682

Step 2

Quote

684

Step 3

Review

686

Step 4

Order

688

Lead Time: No Lead Time Available.

Quote #: 0040003107

Not Reviewed.

Order #:

Generate Drawings

Company Name: 670

Mold Maker:

Customer Ref. # :

Plastic Part # :

Price: \$6,681.00 USD

Contact Name:

Molder:

Requested Delivery Date:

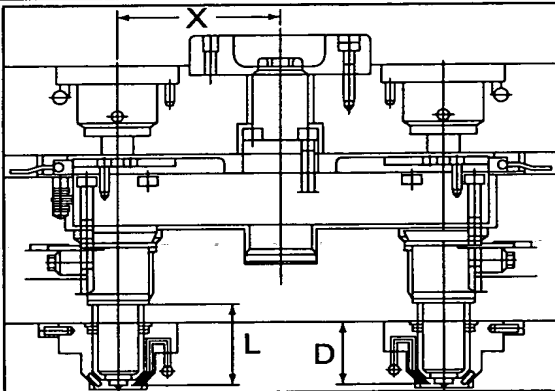
Plastic Part Name:

PO #

N/A

End User:

Industry Segment:



Required Parts List		
Part Number	Description	Options
TS0664P2	MDH C VALVE TS0664 + TSL229	N/A
NZMH1B1A120P	Mim Dura Hecto Valve nozzle L=120	N/A
MNMDH21200BL4VP	2-Inline Sub Manifold	N/A
HY6600D	Hydraulic/Pneumatic Cylinder Assembly	N/A
BP58.750P	Manifold center heater	N/A
LR0081	Locating Ring for Valve system with BP58, inch	N/A

Additional Information

Material	Part	Mold	Other
Material type : Acrylonitrile Butadiene Sty.	Shot Weight : 500 - 3500g	# of Cavities :	Gate Cosmetics :
Grade:	Est. Injection Time (sec.):	Sub-runners:	Gate Cooling:
Supplier:	Wall Thickness:	Gate:	Dim. Stability:

FIG. 35

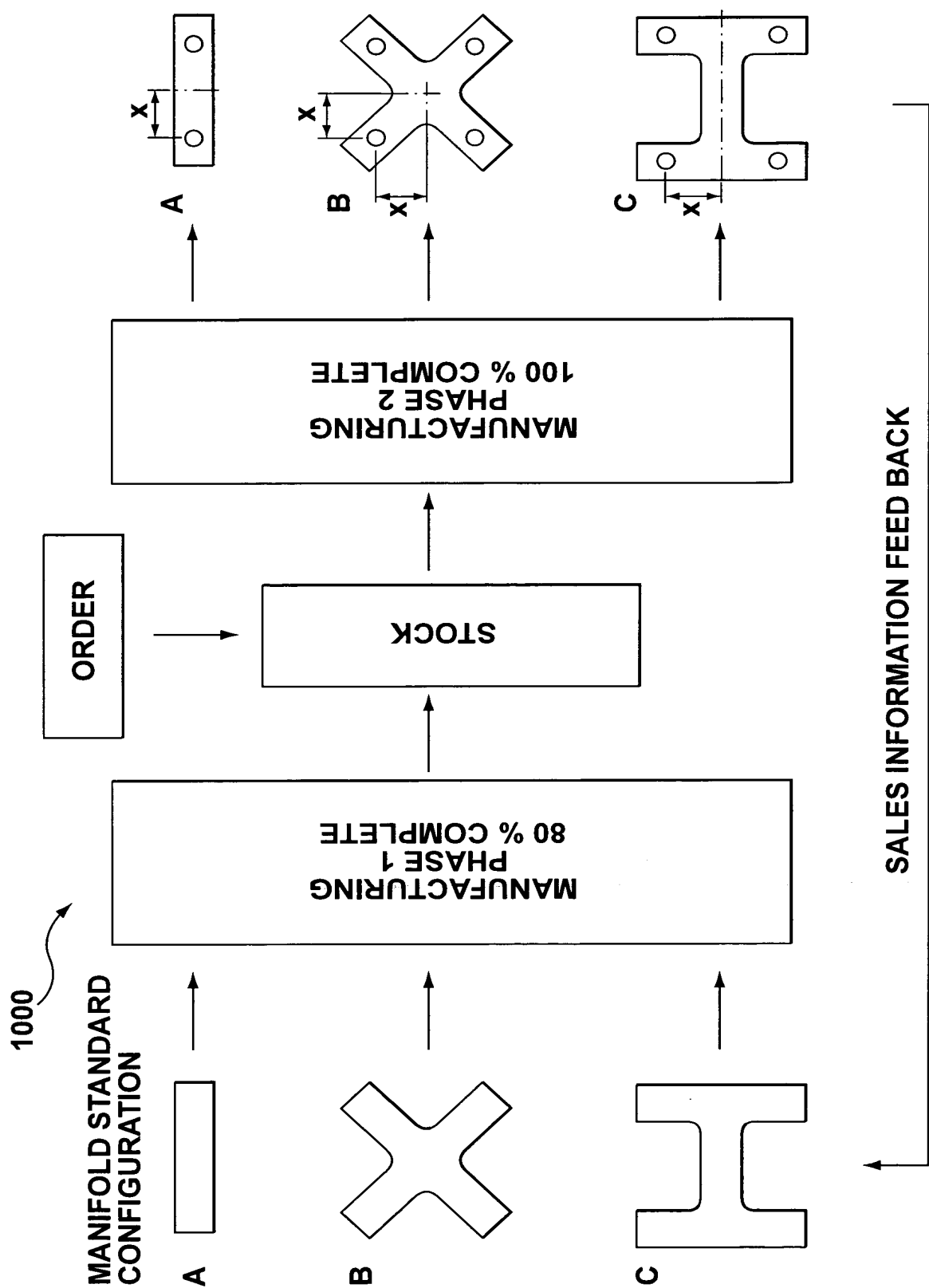


FIG. 36

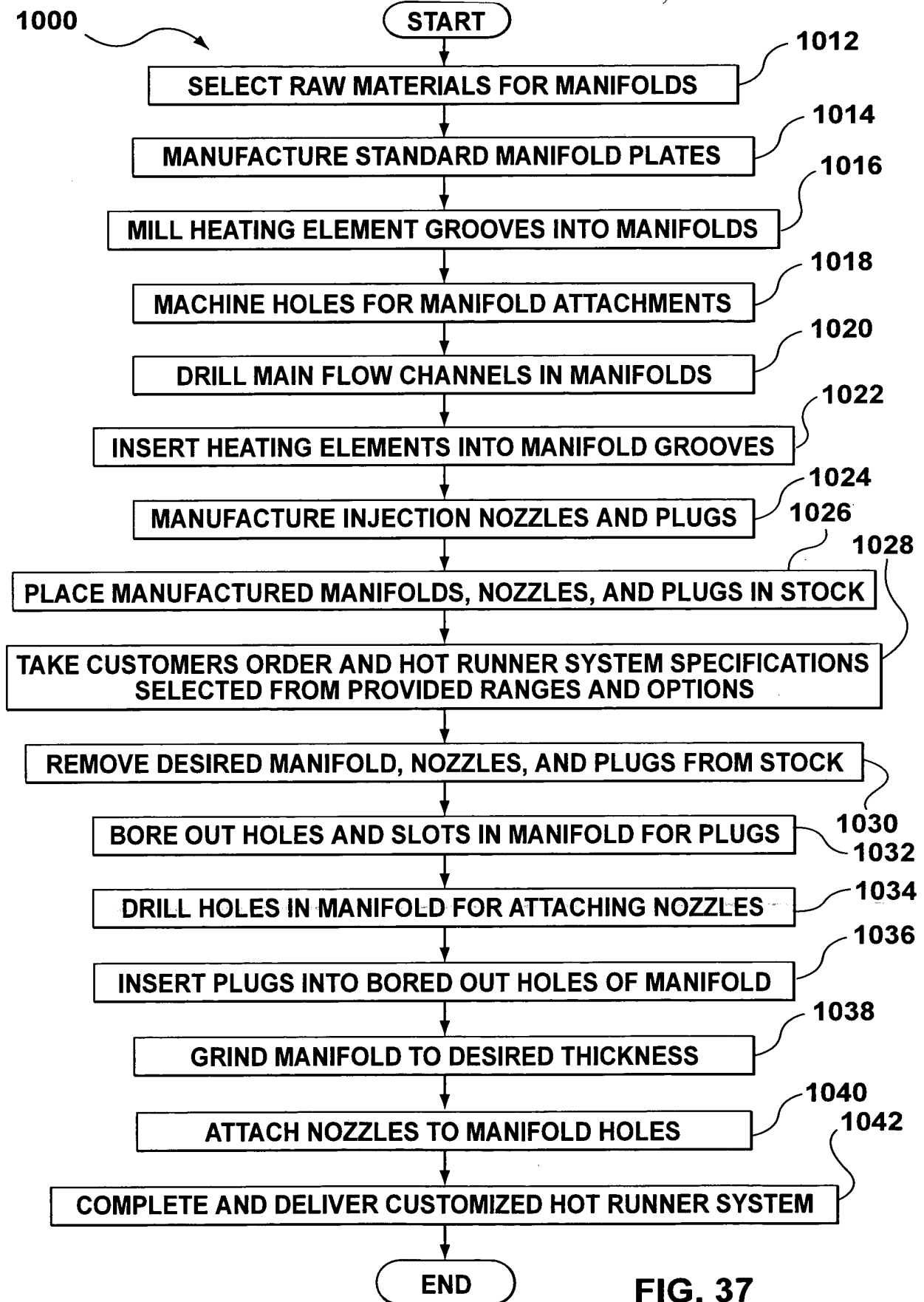


FIG. 37

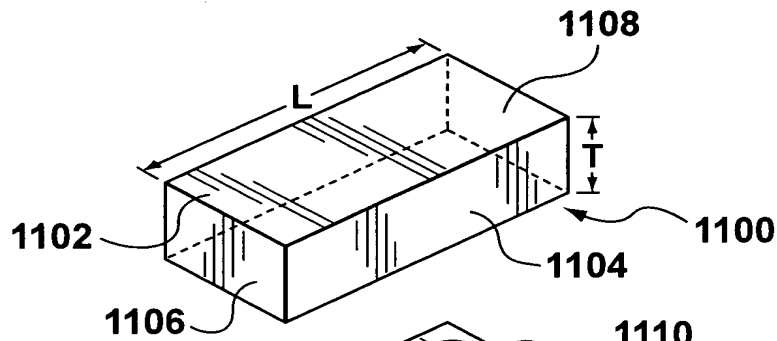


FIG. 38A

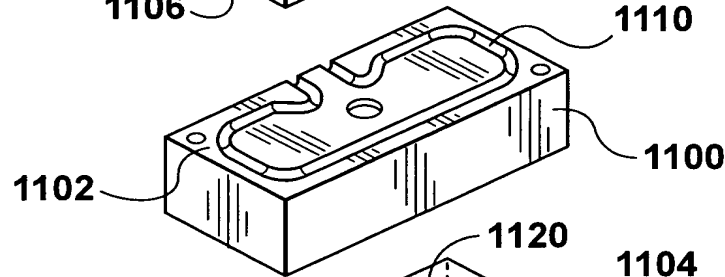


FIG. 38B

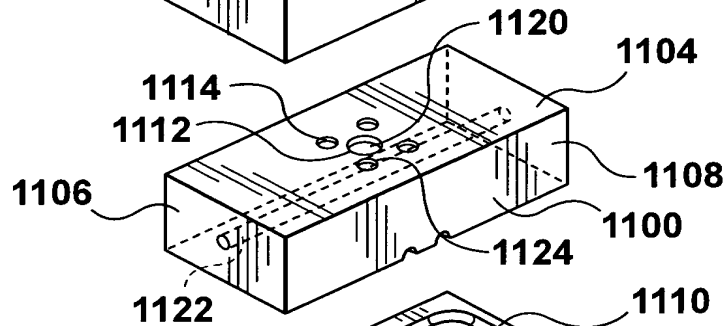


FIG. 38C

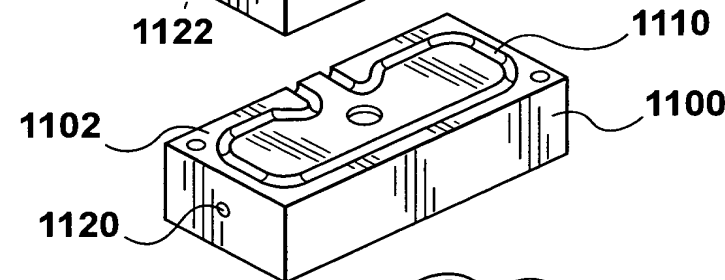


FIG. 38D

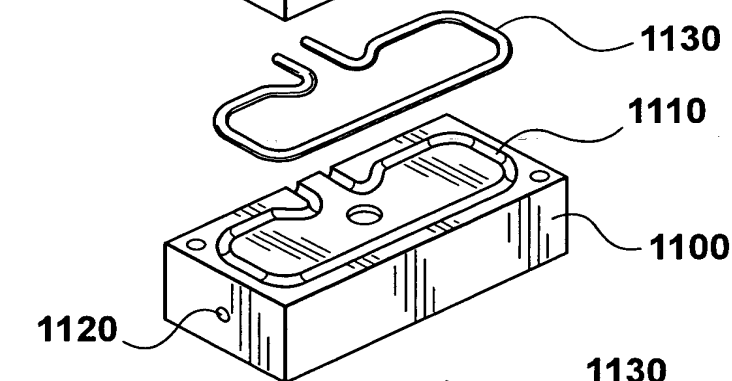


FIG. 38E

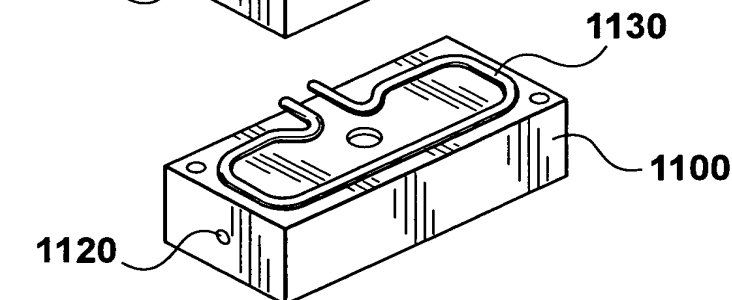


FIG. 38F

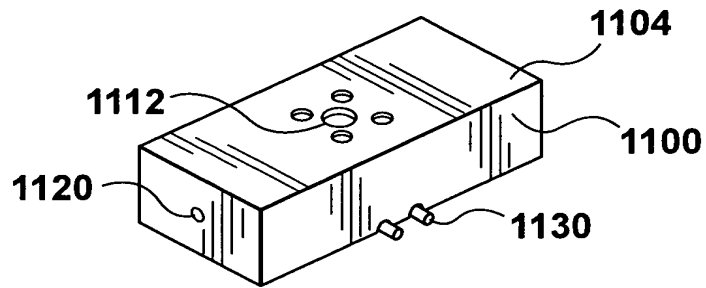


FIG. 38G

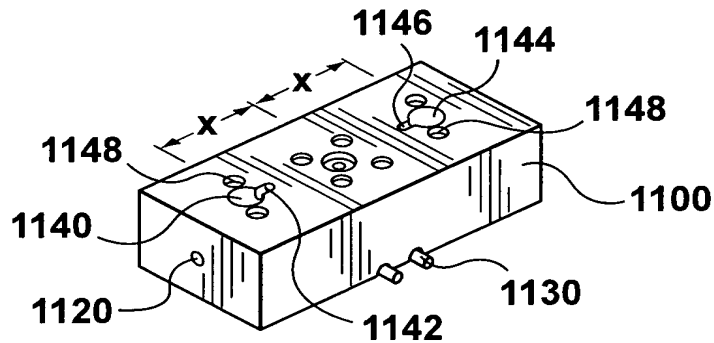


FIG. 38H

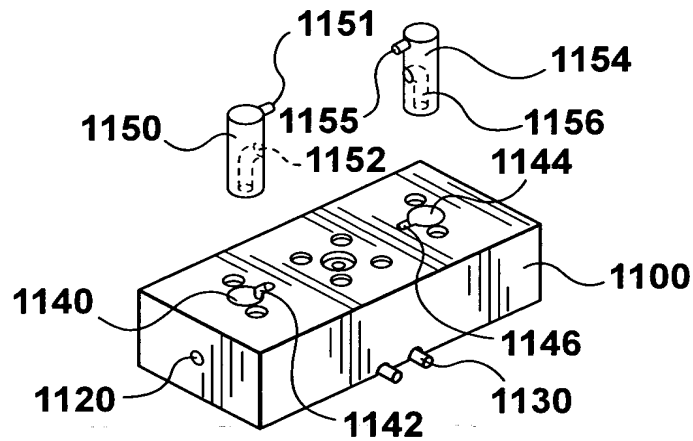


FIG. 38I

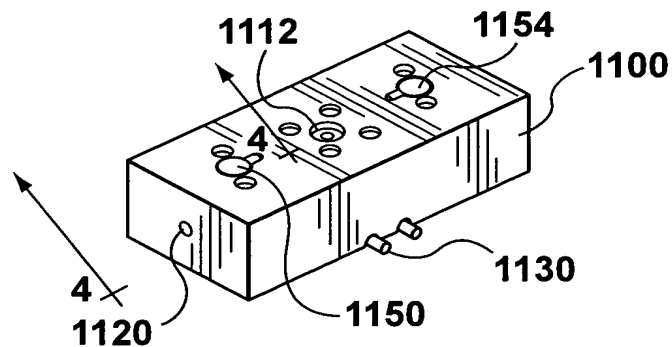


FIG. 38J



MIN SPEED OPTION	MAIN MANIFOLD OPTIONS				
	MANIFOLD BLANK #	X (PITCH RANGE)	L	L1	POWER (WATTS@220V)
✓	MN52I 125BL1	100.00-125.00	322.0	65.7	1650
✓	MN52I 150BL1	125.01-150.00	372.0	90.7	2450
✓	MN52I 175BL1	150.01-175.00	422.0	115.7	2750
✓	MN52I 200BL1	175.01-200.00	472.5	140.7	2500
✓	MN52I 225BL1	200.01-225.00	522.5	165.7	2600
✓	MN52I 250BL1	225.01-250.00	572.5	190.7	2800

FIG. 38K

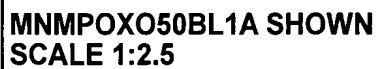
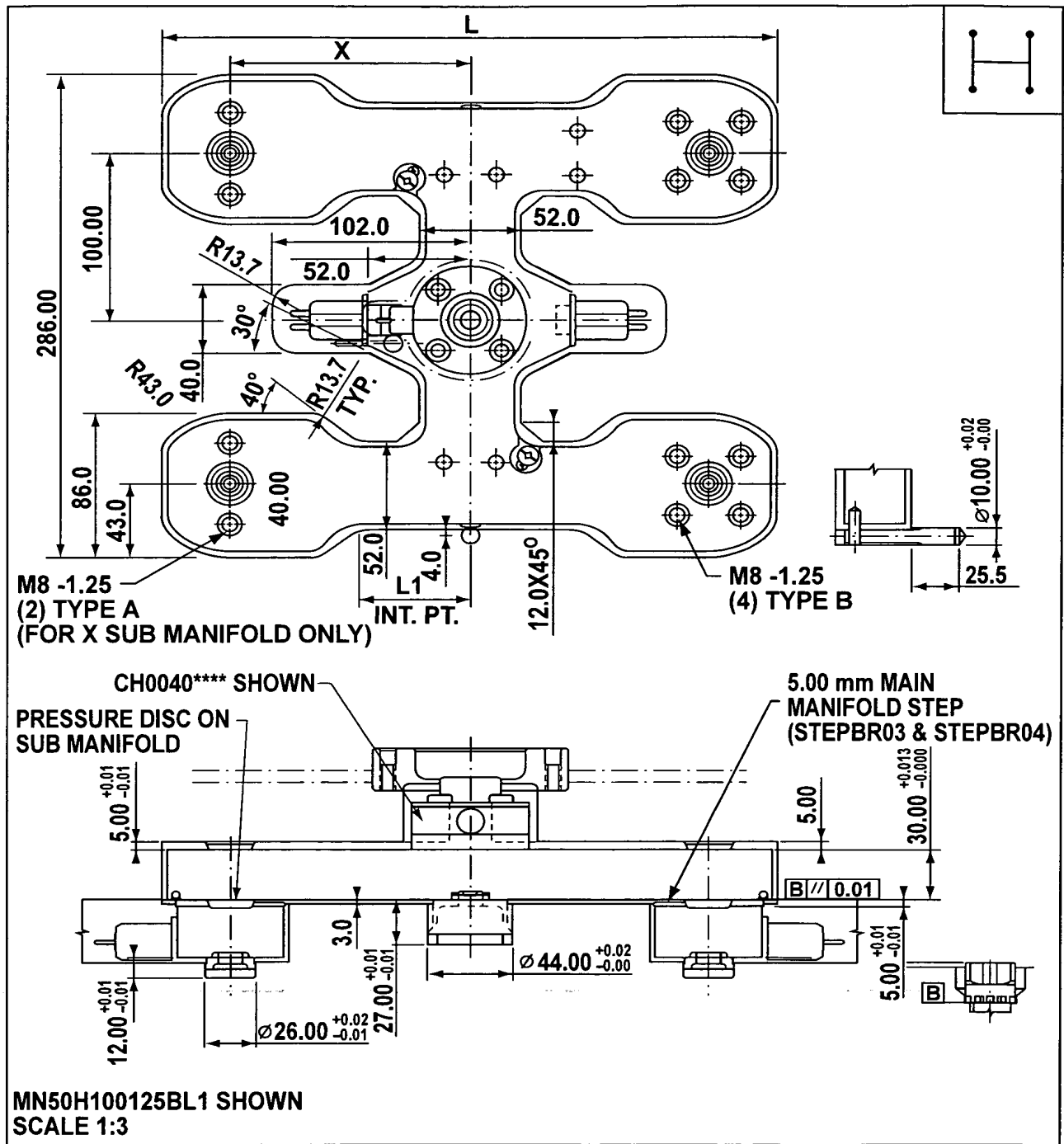


FIG. 38L



MIN SPEED OPTION	MAIN MANIFOLD OPTIONS				
	MANIFOLD BLANK #	X (PITCH RANGE)	L	L1	POWER (WATTS@220V)
✓	MN50H100125BL1	100.00-125.00	322.0	57.3	2200
✓	MN50H100150BL1	125.01-150.00	372.0	82.3	2400
✓	MN50H100175BL1	150.01-175.00	422.0	107.3	2600
✓	MN50H100200BL1	175.01-200.00	472.5	132.3	2800

FIG. 38M

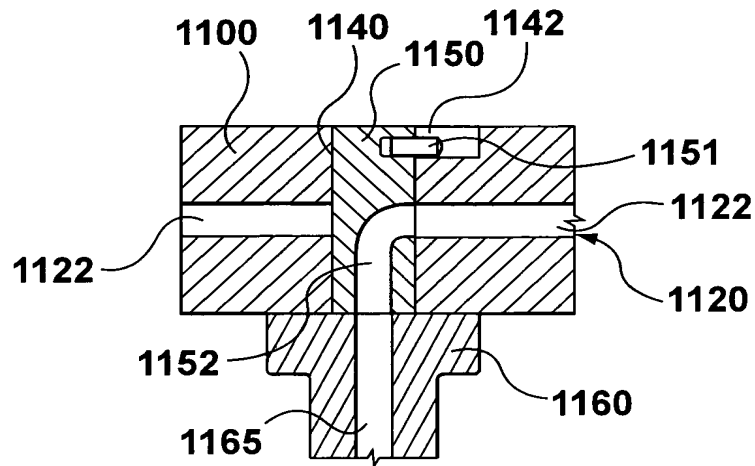


FIG. 39

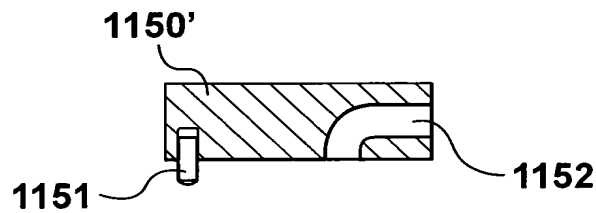


FIG. 40

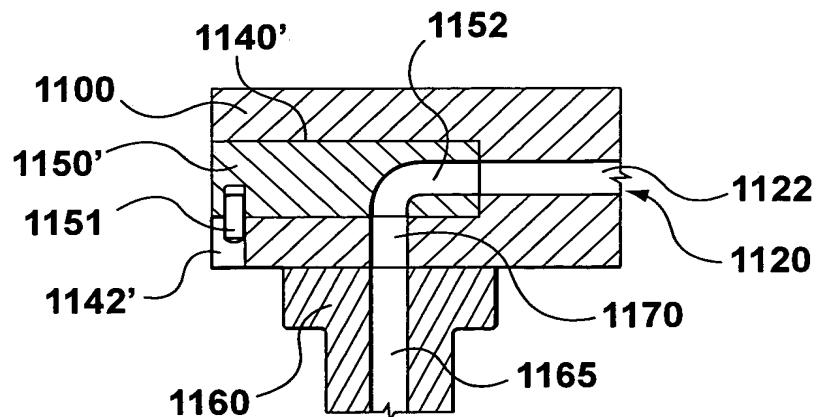


FIG. 41